	YT 2.	(A)	\sim		T T	8866	-
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v		1 1 4		rnei	~	2201	18

88668

Page 1

July-30-12 10:2	2:10 AM		wa e was since creen								
2.44.4	D4017-041	,		Accept	*N900	040	100)* s	etup Star	1 /1	S1*
Item Name:	Short Basket B	ase Assembly (350)							Stop	' * N	S2*
Start Date:	30/07/2012	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date:	13/08/2012	Req'd Qty: 1.00	*1*		Customer:						
Reference:											
Approvals:	Process Plan	n: _ MLJ	Date: 12/07/3	Tooling:	Da	ate:		R	tun Star	I <i>N</i>	R1*
. .	QC:		Date: / /	SPC (Y/N):	Da	ate:	-		Stop	" *N	R2*
Sequence ID/ Work Center II) .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr						A TWO COURSE I AND COURSE SANGER			
D4017	D										
100			S. rod Batch: 41223	5 7 0.00		- ·					
100		Large Fab									
Large Fab		Memo		0.00					1,1		
Large Fab		1- assembl ***inspec	e ribs, weld as per dwg D t before welding mesh***	4017 using D19610B				./	19	13.0	2-122
			d mesh on basket as per doclear fasteners holes on the		o fit if necessary						
		3- weld hir ***take lid	nge (3) and Mounting brac I to locate hinge and brack	kets as per dwg D4017 et***	•						
		4- Weld D	4672-3 blanking plates as	per dwg							
110		QC9- Inspect visual per	r QSI004- Fusion Welds	0.00							DAS.
110 QC Quality Control		Memo		0.00				0	13-0	<u> </u>	09

NCR:	Yes	/	No

	DQA:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:Date:													
NCR:	: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:													
						· ·					QA Closed:	Date:	:	
Vork Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
						Rework	7		Skid-tube	Crosstube]	Water Jet	Engineering	
Part	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is]	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR	No.					Work Order Update]		Large Fab	Composite		Supplier		
Post		I	<u> </u>	1	Doco	ription of work order update		nitial	Δ.	Action				
Root Cause		Date	Step	Qty	Desc	or Non-conformance		niuai ief Eng		ction cription	Sign & Date	Verification	QC Inspector	
oc/Data		Date	Step	Qty		of Non-comormance	101	ilei Liig	Desi	cription	Date	verification	QC Inspector	
uip/Tooling	-						į							
perator	┢						İ							
laterial									!					
etup				1										
ther	$H \mid \cdot \mid \cdot \mid$													
ocess														
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napproved														
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Landi	ng (Gear			_	General					_			
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
	Centre Not Concentric to O/S					BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld	
	├					Burrs		i	ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	├					Contamination	_	Mainte	nance		Part Moved			
						Countersink		Mislabe			Positioned V		7	
Inspection Strip in Tube Cut Too Short						Misread Power Loss/Surg				Surge	Other			
					Drill Holes		Offset							
	Torque W		extrusio	n	Drawing	<u> </u>	ł	Calibration						
		Turning So	equence			Finish	Out of Sequence							

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-30-12 10:22:16 AM

Item ID: Revision ID: Item Name:	D4017-041 Short Basket F	Base Assembly (350)		Accept	*N9000401	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	30/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				
Approvals:	Process Pla	n:	Date:	Tooling:	Date:		Run	Start	*NR1*
					Date:			Stop	*NR2*
Sequence ID/ Work Center II	D .	Operation Description		Set Up/ Run Hours		Plan Accep	ot Rejo Qty		Reject Insp. Number Stamp
120		QC5- Inspect part comp	leteness to step on W/O	0.00					-
120 QC Quality Control		Мето		0.00			_13-	<i>0</i> 9·9	2 09 OAS
							!		
125		Pressure Wash per QSI0	05 4.3	0.00		-	-	N	
125 HandFinish Hand Finishing		Memo		0.00		1	_ 4	U)	13.2-26

												DQA:	D	ate:	
NCR:	Yes	/ No	÷			WORK ORDER NON-C	COI	NFORM	AANCE / UP	DATE		QA Closed:		ate:	
												QA Closed.	U	ate.	
Work Ord	er:				i	DISPOSITION				AGAINST I	DE	PARTMENT,	/PROCESS		
Part I	No					Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Crosstube Small Fab Finishing Composite		1	Water Je d. Eng. Coor re/Packaging Supplie	·	Engineering Quality Other
Root					Descri	otion of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	·	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificati	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
1 1*							AUL	T CATE	3ORY						
Landi	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped.					General Bend BOM/Route Broken/Damaged Burrs		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear				Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing			Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Cuffs Heat Treat Inspection Strip in Tube				Contamination Countersink Cut Too Short	Maintenance Mislabeled Misread				Part Moved Positioned V Power Loss/	•		Other		
	Ripples in Bend				I	Drill Holes	1	Offset							

Out of Cal bration

Out of Sequence

Outside Dimensions

DQA:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-30-12 10:2	?2:16 AM			CODE	20						1 age 5
Item ID: Revision ID: Item Name:	D4017-041 Short Basket B	Base Assembly (350)	·	Accept	*N90004	4 010 0)*	Setup	Start Stop	*NS	S1* S2*
Start Date: Required Date: Reference:	30/07/2012 13/08/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:						
Approvals:		n:		Tooling: SPC (Y/N):	Date:				Start Stop	*NF	R1* R2*
Sequence ID/ Work Center II 130 *130* Powdercoat Powder Coating	D	IST COAT START TIN OVEN TEN FINISH TIN ********* 2ND COAT START TIN OVEN TEN	es and mask only interior of the second mask only interior of the	Set Up/ Run Hours 0.00 0.00 of hinge (3) prior to powder co	at	ool # Plan Code		Qty	6	Number	Insp. Stamp 2-26.
140 *140* QC Quality Control		QC3- Inspect Part Finisl Memo	h	0.00			_B		-	2	Desport

										DQA:	Date:	
NCR: Y	es / N	0			WORK ORDI	ER NON-CO	NFORM	MANCE / UP	PDATE	QA Closed:	Date:	
Work Orde	er:				DISPOS	ITION			AGAINST DE	PARTMENT	PROCESS	
	Cause Date Step Qty				Work Order	Rework Scrap Scrap Jse-as-is Update	p Machining Small Fab is Thermoforming Finishing te Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			,		Description of work orde	er update	Initial	Ad	tion	Sign &		
Cause	Dat	e	Step	Qty	or Non-conformar	ice C	hief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data		-										· · · ·
quip/Tooling												
perator												
//aterial												
etup												
Other						1						
rocess		ŀ										
upplier						1						
raining							i					
Inapproved			:									
						FAU	ILT CATE	GC)RY				

Landir	g Gear	General										
	Bending	Bend		Grain		Ovalized		Pressure/Forced				
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure				
-	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld				
į	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled				
	Cuffs	Contamination		Maintenance		Part Moved		-				
	Heat Treat	Countersink		Mislabeled		Positioned Wrong		_				
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other				
[Ripples in Bend	Drill Holes		Offset								
[Torque Waves in Extrusion	Drawing		Out of Calibration								
	Turning Sequence	Finish		Out of Sequence								
[Wave/Twist in Tube	Folio	· [•							

[.] H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

160

QC5- Inspect part completeness to step on W/O

160 QC

Quality Control

Hand Finishing

Memo

0.00

170

Identify as per dwg & Stock Location/7

0.00

170 Packaging

Packaging

0.00

Page 4

Insp.

								DQA:	Date:	:
es / No				WORK ORDER NON-O	CONFO	RMANCE / UP	PDATE	QA Closed:	 Date:	
r:				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	
0				Rework Scrap Use-as-is Work Order Undate	The	~	Crosstube Small Fab Finishing Composite	1	re/Packaging	Engineering Quality Other
					<u> </u>			<u> </u>	Juppiic: [
Date	Step	Qty	i .	•	i			Sign & Date	Verification	QC Inspector
				F	AULT CA	FEGORY				-
g Gear				General	AULI CA	ILGONT				
Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Hard Inspe Instru Mair Misla Misra Offse	ware action Incomplete actions Incomplete atenance beled ead t f Calibration	/Unclear	Part Incorred Part Lost/Mi Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	g Gear Bending Centre No Cracks Crushed/o Cuffs Heat Trea Inspection Ripples in Torque W	Date Step Date Step Gear Bending Centre Not Concer Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Ripples in Bend	g Gear Bending Centre Not Concentric to Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	g Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Fig. Gear General Bending Bend BoM/Route Centre Not Concentric to O/S Broken/Damaged Centre Not Concentric to O/S Cracks Crushed/Crimped. Burrs Cuffs Contamination Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing	The DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance FAULT CATE Gear General Bending Gentre Not Concentric to O/S BOM/Route Hards Cracks Broken/Damaged Inspection Strip in Tube Countersink Misla Inspection Strip in Tube Cut Too Short Misra Ripples in Bend Drill Holes Offse Ripples in Bend Drawing Out of Strip in Tube Cut Too Short Misra Ripples in Bend Drawing Out of Strip in Torque Waves in Extrusion Drawing Out of Strip in Torque Waves in Extrusion Drawing Out of Strip in Torque Waves in Extrusion Drawing Out of Strip in Torque Waves in Extrusion Drawing Out of Strip Inspection Strip in Tube Out Too Short Misra Counters in Extrusion Drawing Out of Strip Inspection Strip in Tube Out Too Short Misra Counters in Extrusion Drawing Out of Strip Inspection Strip in Tube Out Too Short Out of Strip Inspection Strip in Tube Out Too Short Out of Strip Inspection Strip in Tube Out Too Short Out of Strip Inspection Strip in Tube Out Too Short Out to Shor	Thermoforming Large Fab Step Qty Description of work order update One Step Qty Or Non-conformance Step Qty Or Non-conformance Step Qty Or Non-conformance Step Oty Oty Or Non-conformance Step Oty	PAULT CATEGORY Gear Bending Centre Not Concentric to O/S Cracks	WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: DISPOSITION Rework Scrap Use-as-is Work Order Update Use-as-is Work Order Update Or Non-conformance Date Step Qty Or Non-conformance Bending Centre Not Concentric to O/S Cracks Broken/Damaged Cracks Broken/Damaged Inspection Incomplete Inspection Incomplet	WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date Disposition Rework Scrap Use-as-is Work Order Update Date Step Qty Or Non-conformance Chief Eng Description Date Step Qty Oralized Over/Under tolerance Part Incorrect Over/Under tolerance Part Incorrect Cracks Broken/Damaged Inspection incomplete Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Misraed Positioned Wrong Inspection Strip in Tube Cut Too Short Misraed Prower Loss/Surge Offset Torque Waves in Extrusion Drawing Out of Calibration

Outside Dimensions

Wave/Twist in Tube

July-30-12 10:22:16 AM

Item ID: Revision ID:	D4017-041			Accept	*N900	040	100)* s	Setup			S1*
Item Name:	Short Basket E	Base Assembly (350)								Stop	*N:	S2*
Start Date: Required Date:	30/07/2012 13/08/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Reference:												
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:		F	Run	Start	*N	R1*
	QC:	· ··· • · · · · · · · · · · · · · · · ·	Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Tumber	Insp. Stamp
180		QC21- Final Inspection -	Work Order Release	0.00								_
180 QC Quality Control		Memo		0.00					105		-02-	

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE									DQA:	Da	ite:				
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					
												QA Closed:	Da	te:	
Work Ord	er:					DISPOSITION				AGAINST [Œ	PARTMENT	PROCESS		
Part I	No.					Scrap Machining Sr Use-as-is Thermoforming F Work Order Update Large Fab Cor			Crosstube Small Fab Finishing Composite		ł	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ct	ief Eng Description				Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	ing														
					AUI	LT CATE	GCIRY								
Landing Gear						General		1		_		1			1 .
				Bend BOM/Route	-	Grain Hardwa	ro	}		Ovalized Over/Under	toloranco	H	Pressure/Forced Temperature/Cure		
				Broken/Damaged	\vdash	1	or Incomplete			Part Incorred			Weld		
	<u>⊢</u>			Burrs		4	ions Incomplete/	Unclear		Part Lost/Mi		\vdash	Wrong Stock Pulled		
					Contamination		Mainte			Part Moved					
					Countersink	\vdash	Mislabe				4	ositioned Wrong			
	⊢				Cut Too Short	Misread				Power Loss/	-	Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Picklist Print

July-30-12 10:22:19 AM

Work Order ID: 88668

88668

Parent Item:

D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 30/07/2012

Required Date: 13/08/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.11.30 verified by:EC

IPP Rev:B as

per dwg RevA DD 10.03.06 verified by:EC RevB DD 10.04.16 verified by:EC

IPP Rev:C as per dwg IPP Rev:D as per dwg revC DD

10.08.18 verified by:EC

IPP Rev:E 10.11.04 added pressure wash

DD_verf·EC

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	D4672-3		Manufactured	No			100	Each	20.0000	2	2			
√	*D4672-3* Blanking Plate									**		147->2	x S) 1302-22
					Location		Loc	<u>Otv</u>	Loc Code					
					ST241A			20		_		_		
						87747 87915		8 12		_	· -			
	D4017-1		Manufactured	No		0,713	100	Each	3.0000	1	1	_		
J	*D4017-1*									** B	860	15-2/1	(S)	113.02.20
					Location		Loc	<u>Oty</u>	Loc Code					
					WA			3				_		
						59957		0		_				
	D4018-1		M C . 1	N.		74318	100	3		_		_		
,	,		Manufactured	No			100	Each	16.0000	1	1			
J	*D4018-1*									** 7	3860	016 -> 1	x de	113.00.20
					Location		Loc	<u>Oty</u>	Loc Code					

D4018-1 is the same as D4017-3

WA - 11 86016 11 5

5

WA005 72545

											DQA:	Date	•
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	:
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	Part No NCR No Root De					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	LT CATE	GORY				
Landi		ear Bending Centre No Cracks Crushed/O Cuffs Heat Trea	Crimped,	ntric to (o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		- 1 1	on Incomplete ions Incomplete/ nance	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	$\boldsymbol{\vdash}$	Inspection		Tube	ļ —	Cut Too Short		Misread		<u> </u>	Power Loss,		Other
	П	Ripples in	Bend			Drill Holes		Offset		!	_	_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

July-30-12 10:22:19 AM

Work Order ID: 88668

88668

Parent Item:

D4017-041

D4017-041

Location

WA

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 30/07/2012

Required Date: 13/08/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-5

Manufactured No 100

Each

5.0000

B76379 JU 13.02.20

D4017-7 √*D4017-7* Manufactured No WA005 76379

5 5 100 Each

Loc Qty

15.0000

Loc Code

**

B95102 Sy 13-02-20

Location Loc Qty Loc Code WA 82969 87010 10 WA005 69730 85435 3

** 389395 + 2x

D4017-9

Manufactured

Location Loc Qty

100

81445 86528 10 WA006 70341

2

Each

Loc Code

13.0000

Ad 13.02.20

											DQA.	Date.	
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
									1		QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
Part I	_			y. v	`	Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update	1	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	puip/Tooling perator paterial perator paterial perator							T CATE	CODY				
Landi	ng Ge	ar				General	AUL	T CATE	JURY				
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Instructi Mainte Mislabe	on Incomplete ons Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled		
	Inspection Strip in Tube					Cut Too Short	Misread				Power Loss/	Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

July-30-12 10:22:19 AM

Work Order ID: 88668

88668

Parent Item:

D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 30/07/2012

Required Date: 13/08/2012

						:	Start Qty:	1.00 Required Qty: 1.00
D3916-041 / *D3916-041* Rib Assembly	Manufactured	No		100	Each	12.0000	2 **	2 B94048 SS13-02-20
•			Location	L	oc Qty	Loc Code		B92672+J
			WA		10			·
			86519		4			
			86539		6			· ·
			WA006		2			
D3916-5	Manufactured	No	81444	100	2 Each	20.0000		·
√*D3916-5*	Manutactured	140		100	Eacn	20.0000	**	B94163 Sy 13-02-20
Light Rib								D 17165 XV313-00-00
			Location	<u>L</u>	oc Qty	Loc Code		
			WA		20			
			77142		1			
			82933 85930		4 6			•
			85931		9			
D4034-041	Manufactured	No		100	Each	3.0000	1	1
✓ *D4034-041* Aft Upper Rib Assembly							**	B94048 SH 13.02.20
The opportunity is			Location	L	oc Qty	Loc Code		
			WA	<u>=-</u>	3	<u> Loc Couc</u>		
			82978		3			
D4034-043	Manufactured	No		100	Each	4.0000	1	1
/ *D4034-043* Fwd Upper Rib Assembly							**	794042 Sy 12.00.20
			Location	La	oc Qty	Loc Code		
			WA		4			
			81175		3			
			83756		1			
July-30-12 10:22:19 AM			Shop I	Packet Print				Page 3

											DQA:	Dat	e:
NCR:	Yes	/ No				WORK ORDER NON-O	CON	IFOR	MANCE / UPI	DATE			
						Y					QA Closed:	Dat	e:
Work Ord	er:					DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS	
Part I						Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					- Descri	ption of work order update	lı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F	AUL	CATE	GORY				
Landi					_	General			÷	_	_	-	
		Bending Centre No	ot Concer	ntric to	o/s	Bend BOM/Route		Grain Hardwa			Ovalized Over/Under		Pressure/Forced Temperature/Cure
	-	Cracks	C:			Broken/Damaged	\vdash	•	on Incomplete		Part incorre	<u> </u>	Weld
	\blacksquare	Crushed/0 Cuffs	crimpea.		<u> </u>	Burrs Contamination	\vdash		ions Incomplete/L	Inclear	Part Lost/Mi	issing [Wrong Stock Pulled
	Н	Heat Trea	+		-	Countersink	\vdash	Mainte Mislabe		<u> </u>	Part Moved	11	
	Н	Inspection		Tuhe	-	Cut Too Short	\vdash	Misread		-	Positioned V Power Loss/	· ·	Other
	-	Ripples in		· une	<u> </u>	Drill Holes	\vdash	offset	4	L	Trower ross/	onike [Other
	-	Torque W		xtrusia	<u>,</u>	Drawing	\vdash		: Cal:bration				
	$\boldsymbol{\vdash}$	Turning So		4510		Finish	\vdash		Sequence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-30-12 10:22:19 AM

Work Order ID: 88668

88668

Parent Item:

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

D4017-041

Start Date: 30/07/2012

Required Date: 13/08/2012

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured

100

Each

132.0000

**

B8857Y→2x Ly 13-02-20

<u>Location</u>	<u>Lo</u>	<u>c Oty</u>	Loc Code	
WA		114		
82506		2		
83230		3		
85452		24		
86058		12		
86367		39		
86961		34		
WA005		18		
70766		2		
81253		1		
82897		15		
	100	Each	12.0000	i

D3913-15

Manufactured

No

No

**

Location Loc Qty Loc Code WA 87011 87867 3 WA005 5 86139

July-30-12 10:22:19 AM

Shop Packet Print

Page 4

										DQA:	Date	2:
NCR: Y	es / No				WORK ORDER NON-	CON	FORM	MANCE / UP	DATE	QA Closed:	Date	
						Т						
Work Orde	er:				DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part N	lo				Rework Scrap		l	Skid-tube Machining	Crosstube Small Fab	-4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		İ										
Operator												
Material												
Setup		Ì										
Other												
Process												
Supplier								•				
Training												
Unapproved												
					<u> </u>	AULT	CATE	GCIRY				
Landin	g Gear			_	General					_	_	_
1	Bending				Bend	Ц	Grain	•		Ovalized		Pressure/Forced
1	Centre No	ot Concer	ntric to C)/s	BOM/Route		Hardwai	re [·]		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushed/	Crimped.			Burrs		nstructi	oris Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
Ĺ	Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset			_	_	
	Torque W	/aves in E	xtrusion		Drawing		Out of C	alibration				
	Turning S	equence			Finish	\Box	Out of S	equence				

Outside Dimensions

Wave/Twist in Tube

July-30-12 10:22:19 AM

Work Order ID: 88668

Parent Item:

D4017-041

D4017-041

Location

Location

WA035

WA

86166

66418 85437

81442

84972 86536

87008 87235

ST044

WA

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 30/07/2012

Required Date: 13/08/2012

Start Oty: 1.00

Required Oty: 1.00

D4016-1

Manufactured No 100

100

100

Loc Oty

48 0000 Each

3 B93117 -> 3x LU.13-02-20

D4020-3

Mesh (350 Basket Short, Base) D4020-11

End Mesh, Basket

Manufactured No

Manufactured No

Each

Loc Qty

21

2

4

20

12

Each

33.0000

Loc Code

0.0000

Loc Code

**

**

B95/15 SH 13.00-21

B95016 SH 13.00.21

						•					DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UPDA	ATE			
						- ₁					QA Closed:	Date	e:
Vork Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part NCR						Rework Scrap Use-as-is Work Order Update		ī	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	ł	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				1	Descr	ription of work order update	T	Initial	Actio	n	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descrip	tion	Date	Verification	QC Inspector
oc/Data													
uip/Tooling		}											
perator													
aterial													
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ther													
ocess													
ıpplier													
aining													
napproved													
						F	AUI	T CATE	GORY				
Landi	ng (Gear				General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	:t	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Und	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	_	
		Heat Trea	t			Countersink		Mislabe	led		Positioned W	V rong	
Inspection Strip in Tube Cut Too Short							Misread			Power Loss/:	Surge	Other	
Ripples in Bend Drill Holes Offset							Offset						
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Picklist Print

July-30-12 10:22:19 AM

Work Order ID: 88668 Parent Item: D4017-041 *D4017-041* Parent Item Name: Short Basket Base Assembly (350) Start Date: 30/07/2012 **Required Date: 13/08/2012** Required Otv: 1.00 Start Otv: 1.00 D4021-1 No 100 Manufactured Each 47.0000 B88353+3x *D4021-1* Handle Plate SH 13-02:20 Location Loc Otv Loc Code WA 69518 74316 0 74946 85785 87009 10 87330 31 D2931 150 Manufactured No Each 2.378,000 ** Bumper Location Loc Qty Loc Code ST504 2378 46064 378 86435 2000 D4021-5 150 No 34.0000 Manufactured Each ** Blanking Plate 89059 Loc Code Location Loc Qty ST084 13 85065 2 85891 11 ST088 21 87055 21

											DC	A:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UP	DATE				
											QA Close	ed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DI	PARTME	NT/PROCES	SS	
Part						Rework Scrap		3	Skid-tube Machining	Crosstube Small Fab		Wate Prod. Eng. C	Coor.	Engineering Quality
NCR No.					······	Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/S	tore/Packa Sup	ging plier	Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Descr	ription	Date	Verifi	cation	QC Inspector
Doc/Data														
Equip/Tooling														
Operator									ı			1		
Material									ĺ					
Setup	П													
Other														
Process														
Supplier					·									
Training														
Unapproved							1		i					
			•	<u> </u>	•		AUI	T CATE	GORY					
Landi	ng (Gear				General								
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ıre		Over/Und	der toleranc	e	Temperature/Cure
		Cracks			<u></u>	Broken/Damaged		Inspecti	ion Incomplete		Part Inco			Weld
		Crushed/	Crimped.			Burrs		1 .	iors Incomplete/l	Unclear	Part Lost	/Missing		Wrong Stock Pulled
						Contamination	Maintenance				Part Mov	•	L	1 0 111 11194
	П	Heat Trea	ıt			Countersink	Mislabeled			Positioned Wrong				
	П	Inspectio		Tube	-	Cut Too Short	\vdash	Misread			Powerlo	•] _{Other}

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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July-30-12 10:22:19 AM

Work Order ID: 88668 *88668* Parent Item: D4017-041 *D4017-041* Parent Item Name: Short Basket Base Assembly (350) **Start Date:** 30/07/2012 **Required Date: 13/08/2012** Start Qty: 1.00 Required Qty: 1.00 AN3-10A No Purchased 150 Each 71.0000 *AN3-10A* ** Location Loc Code Loc Qty ST351 71 117795 2 120873 69 AN960JD8 NAS1149DN832 Purchased No 150 0.0000 Each 123525 C13/57 *AN960.ID8* ** Washer MS20600-AD4W3 Purchased No 150 Each 1,702.000 *MS20600-AD4W3* ** Cherry Rivets Location Loc Oty Loc Code 311 582 122452 582 ST314 516 122151 516 ST321 471 111636 36 117601 3

200

232

133

133

118626

120308

107939

WA018

										DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	CONFORI	MANCE / UF		QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	_					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descrip	otion of work order update	Initial	1	ction	Sign &		
Cause		Date	Step	Qty	0	r Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup ther rocess upplier												
raining napproved												·
						F	AULT CATE	GORY				

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Landing Gear

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped_

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

July-30-12 10:22:19 AM

Work Order ID: 88668

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

88668

D4017-041

Start Date: 30/07/2012

Required Date: 13/08/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Parent Item:

Purchased

No

150

Each 3,796.000

___123900

MS21042L3

Location	Loc Oty	Loc Code		
316	899			
122452	899			
ST300	897			
117885	32			
119017	704			
119075	138			
121444	23			
ST317	2000			
122141	2000			
	150 Fach	1.510.000	12	12

NAS1149F0332P

Purchased

No

**

Ju 3/2/20

NAS1149F0332P WASHER

Logotic		LacOta	t C-1
Locatio	<u>)11</u>	Loc Qty	Loc Code
275		600	
	122441	600	
ST275		910	
	117735	13	
	119225	10	
	120986	82	
	121259	188	
	121825	14	
	122063	600	

		_	_	
			_	
_			-	
			-	
		_	0	

17317

												DQA:	Da	ite:	
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
QA Closed: Date:															
Work Ord	Work Order:					DISPOSITION AGAINST D			Εŧ	EPARTMENT/PROCESS					
Part No				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fall Use-as-is Thermoforming Finishing		Crosstube Small Fab Finishing Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other			
Root					Descri	ption of work order update		Initial	Ac	tion	٦	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Desc	ription		Date	Verificatio	'n	QC Inspector
Doc/Data											T				
Equip/Tooling															
Operator							1								
Material							Ì								
Setup				:							ļ				
Other											1				
Process		-									1				
Supplier															
Training											١				
Unapproved											١				
						F	AUI	T CATE	GCIRY		_				
Landing Gear General															
		Bending				Bend		Grain			٦	Ovalized			Pressure/Forced
		Centre Not Concentric to O/S BOM/Route			Hardwa	re		٦	Over/Under	tolerance		Temperature/Cure			
				Broken/Damaged		Inspection Incomplete			٦	Part Incorrec	ct		Weld		
	Crushed/Crimped. Burrs			Burrs		Instruct	ions Incomplete/	Unclear	٦	Part Lost/Mis	ssing		Wrong Stock Pulled		
	Cuffs Contamination				Maintenance			\neg	Part Moved	-					
	Heat Treat Countersink			Countersink		Mislabeled Positioned Wrong									
	Inspection Strip in Tube Cut			Cut Too Short		Misread			٦	Power Loss/S	Surge		Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G









